

Work Order ID 79302

79302

Page 1

January-24-12 1:55:57 PM

Item ID: D3023-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back Panel
 Start Date: 24/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 12/01/24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3023	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D3023								
<u>2024. 032</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	***graind direction along 28.100" ***								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

W 12.03.12 (1)

W 12.03.12 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120		0.00							
QC	Memo								
Quality Control									
180	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
180		0.00							
Packaging	Memo								
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190		0.00							
QC	Memo								
Quality Control									

MLJ 12/04/02
 (P)

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Picklist Print

January-24-12 1:56:02 PM

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Work Order ID: 79302

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Parent Item: D3023-1

D3023-1

Parent Item Name: Back Panel

Start Date: 24/01/2012

Required Date: 07/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.01.23Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

106.7000

2.8777

3.029158

**

nl 12.03.12

M2024T3S 032

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	79302
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.128	✓		VWV	HB-02
Ø0.191	+0.005/-0.001	0.191	✓		VWV	" "
1.660	+/-0.010	1.670	✓		VWV	" "
0.375	+/-0.010	0.380	✓		VWV	" "
1.340	+/-0.010	1.338	✓		VWV	" "
2.375	+/-0.010	2.377	✓		VWV	" "
0.375	+/-0.010	0.380	✓		VWV	" "
25.28	+/-0.030	25.28	✓		M.T	HB-01
27.03	+/-0.030	27.03	✓		M.T	" "
28.10	+/-0.030	28.10	✓		M.T	" "
1.30	+/-0.030	1.33	✓		VWV	HB-02
2.375	+/-0.010	2.342	✓		VWV	" "
8.711	+/-0.010	8.713	✓		VWV	Prod-w-5-02
5.597	+/-0.010	5.599	✓		VWV	" "
8.57	+/-0.030	8.57	✓		M.T	HB-01
1.970	+/-0.010	1.975	✓		VWV	HB-02
7.42	+/-0.030	7.42	✓		M.T	HB-01
10.92	+/-0.030	10.92	✓		M.T	" "
14.75	+/-0.030	14.75	✓		M.T	" "

Measured by:	WHL
Date:	12/03/12

Audited by:	S
Date:	12/03/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS

.064
.095

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

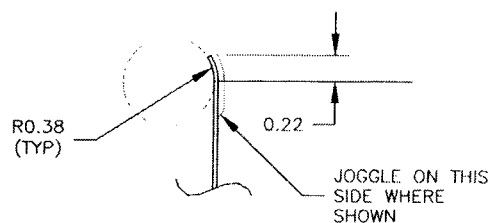
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

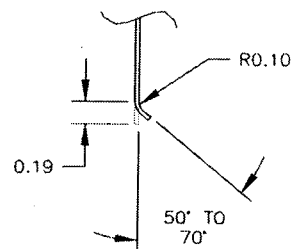
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SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



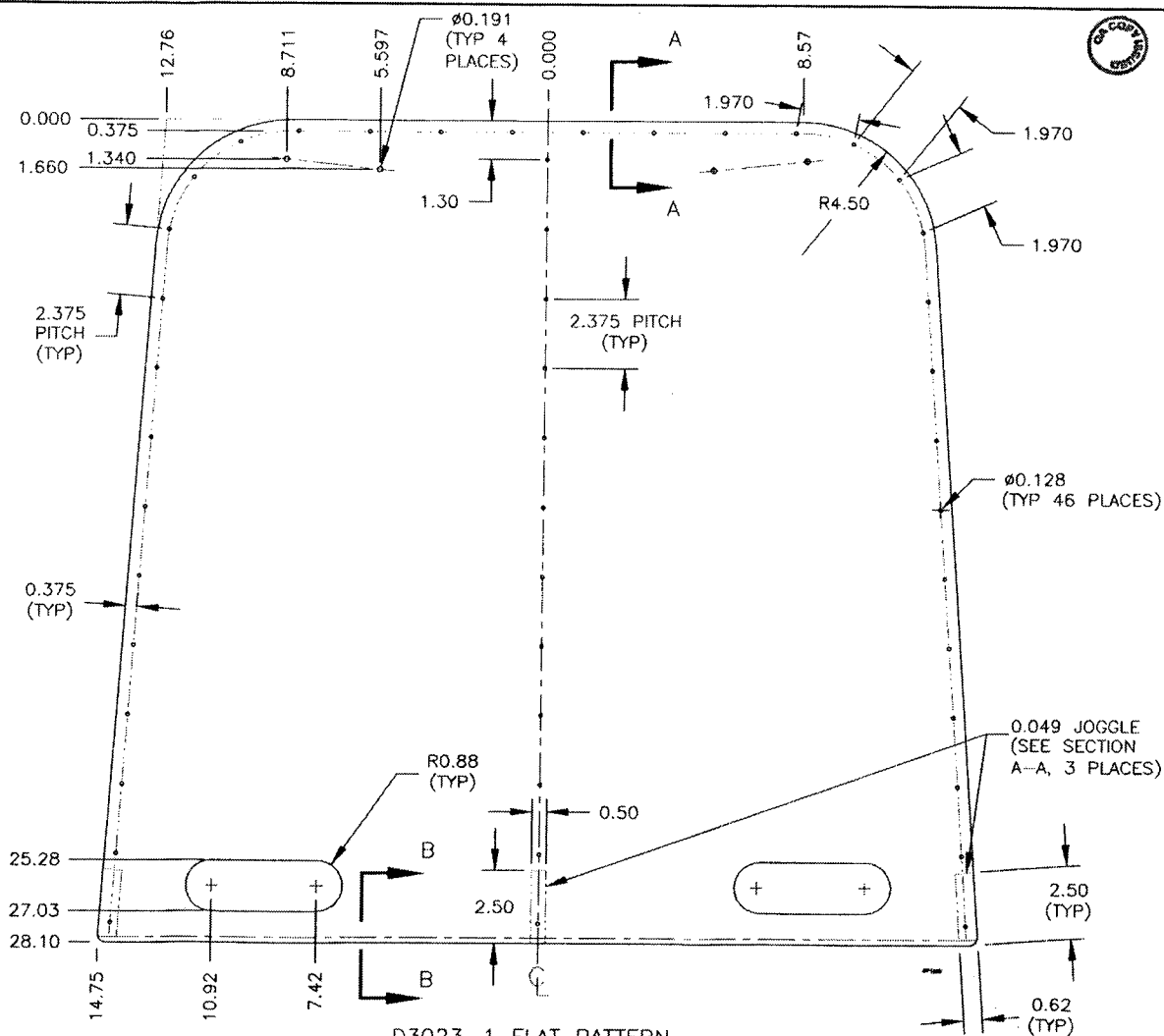
SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



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SURVIVED

NO. 79302
MLJ
12/01/24

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WARRICKSURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	TITLE	BACK PANEL
01.05.18		SCALE 1:4

REV. A
SHEET 1 OF 1

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